

Project technical Data

<u>Minimum Length</u>	150	mm	6,0	inches
<u>Maximum Length</u>	813	mm	32,00	inches
<u>Minimum Width</u>	75	mm	2,95	inches
<u>Maximum Width</u>	400	mm	15,75	inches
<u>Minimum Thickness</u>	10	mm	0,2	inches
<u>Maximum Thickness</u>	50	mm	1,97	inches
<u>Max. bow/PANEL</u>	10 mm Over 1,000 mm		13/32" over 39"	
<u>Designed line speed</u>	12	m/min	39,36	fpm
<u>Production Capacity</u>	To be determined by the production requirements and the requirements of the coating supplier. Historical records and laboratory testing are the most valuable in developing these parameters.			

Additional information

<u>Standard colors</u>	Grey RAL 7035
<u>Control Side of Line</u>	Right
<u>Standard voltage</u>	Working tension 480V/60 Hz. Commands 24V. Max. allowed oscillation +/- 5%
<u>Components</u>	Prices are based on the use of our standard mechanical (Bonfiglioli), electrical and electronic (Schneider Telemecanique) components. Requests for other manufactures equipment to be supplied instead of our standard components can be evaluated for performance, reliability and any extra costs that may be incurred
<u>Design Criteria</u>	Machines designed for NEC Class I Division 2 installation. Complies with all UL, CUL and CSA regulations. User must foresee an adequate technical ventilation in the working environment in order to prevent any risk of inflammability. User must verify that the zone in which the machine or installation will be positioned is right for the purpose.
<u>Commissioning and start-up</u>	For single machines shipped when already assembled, the commissioning and start-up is carried out at Giardina premise. For disassembled machines or groups of machines, start up will be carried out after commissioning.

Price List

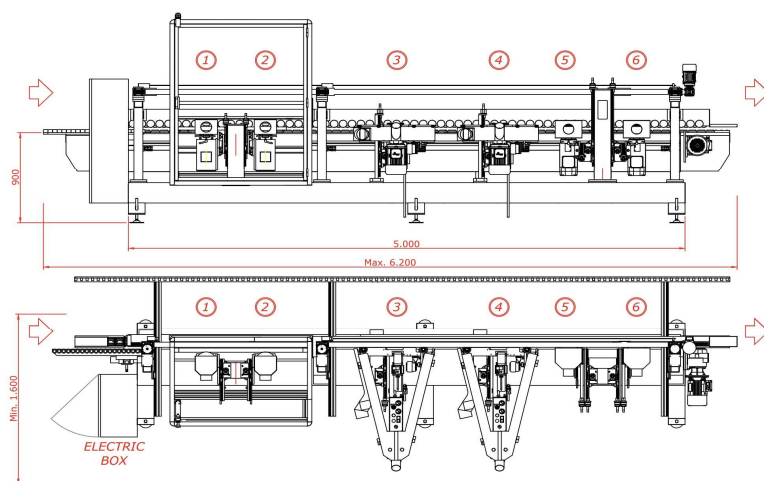
Pos.	Type of machine	Price of the machine	Price of the optional

1 Single Side Edge Sanding Machine right TYPE mod. MVT 5.000 (5 units)

Nr. 1 Sanding wheel units model TP L-M + Nr. 1 TP L-F

Nr. 2 Sanding belt units model AT 110

Nr. 1 Sanding wheel units model SB



1.1 Running speed adjustable by inverter

included

1.2 Infeed square for narrow workpieces

included

1.3 Hubs + 1 spare set of abrasives (5 belts per AT & 2 felt pads per AT)

included

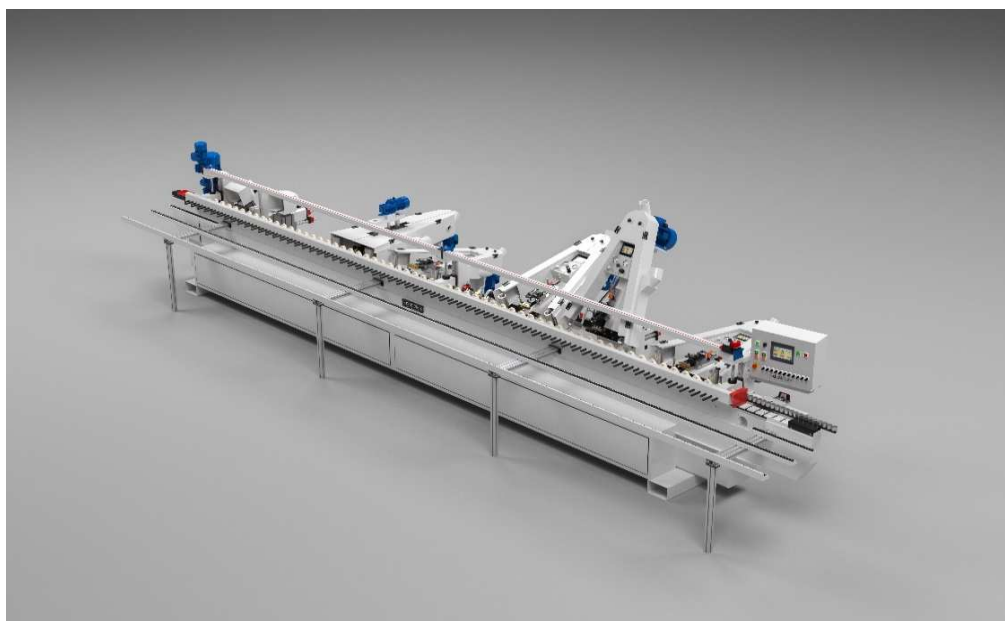
Machines descriptions

with

technical characteristics

Pos.	Machine description
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- | | |
|---|--|
| 1 | <u>Single side edge and profile sanding machine type MVT</u> |
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All images are inserted for illustrative purposes. The products are subject to changes.

Automatic one side machine capable of sanding edges of panels or profiles made of the following materials: MDF, chipboard, plywood panels, solid timbers or other materials of panels sides and sanding UV, PU, PY veneered surfaces or other types of finishes
(Processing of one panel side for each pass or top and lateral on profiles).

STRUCTURE:

Machine bed with appropriate dimension that permit high stability and resistance during the processing work, the base together with the plates on which the units are fixed build a strong structure, able to absorb the vibrations and grant a perfect stability during intensive production.

The support plane that permit entertain the sanding groups is worked to assure the support in square of the groups.

On the inferior area the machine bed is supplied of adjustment screws for being better suitable at the paved area.

TRANSPORT CHAIN:

Track composed of a steal chain on changeable antifriction track pads, carrying rubber covered steel plates.

The tracks run on two flat changeable guides, for long lasting and perfect running.

Drive motors with electronically speed variation by INVERTER (SCHNEIDER).

PANEL INFEED:

The feeding of panels is aided by an extended infeed fence, hence giving maximum guidance at the infeed of the machine.

Adjustable right-hand fence with digital readout.

MOTORIZED TOP PRESSURE BEAMS:

With rubber wheels each mounted on a ball bearing.

Wheels are staggered for better holding even on short pieces.

SUPPORT BAR FOR PANELS:

An extractable rollers line (plastic idler rollers) help to support the panels particularly heavy or bulky such as doors.

CONTROL PANEL:

Separate desk cabinet, positioned at the infeed of the machine.

The control panel contains the operating controls of all the working units by switch and an emergency switch.

The automation of all the working units is handled by an Electronic Control type TOUCH SCREEN. Electronic control fitted on the electrical box, with this control there is also an encoder fitted to the transport.

9.7" Display Touch Screen.

CONTROL PANEL FUNCTIONALITY

ABRASIVE BELT SANDING UNIT WITH PAD

Control pad on the belt sanding units (Input and Output sanding pad).

Control time of the airflow for cleaning blower on the sanding belt units (opening and closing the air flow to clean the sanding belt).

Control and program the cutting speed on the sanding belt units (m/sec).

SANDING DISC UNITS:

Control and program the jumping movement of the brush unit (In/Out).

Program the sense of rotation for each sanding disc unit (clockwise or counter clockwise).

Visualization and program the sanding speed disc (rpm).

MACHINE:

Visualization and program the feeding speed (m/min).

Visualization of the number of worked pieces (with reset).

Visualization of the linear meter worked with reset (mt).

Visualization of the time worked (with reset).

Visualization of the ALARMS.

Choice of languages (Italian, English, German, etc.).

EEC standards:

UL/CSA MOTORS AND ELECTRIC COMPONENTS.

MACHINE CONFIGURATION:

MVT 5.000

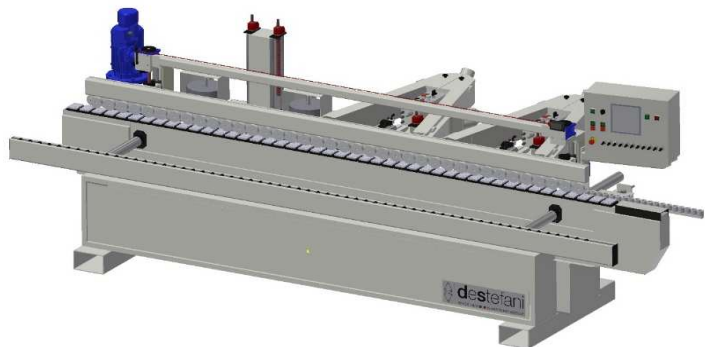
pos. 1 - TP L-M wheel unit with timed intervention

pos. 2 - TP L-F wheel unit

pos. 3 - AT belt unit

pos. 4 - AT belt unit

pos. 5 - SB wheel unit



TECHNICAL DATA:

Working side: 1 - single side machine

Processing: sanding

Min. length: 200 mm

Min. width: 50 mm

Max. Thickness: 100 mm

Variable feeding speed by inverter: from 5 to 25 m/min

Feed motor power (with inverter): 1.5 kW

Working height (+/- 30 mm): 900 mm

Total installed power: 8.5 kW

Voltage: 480 V (3 phases, 60 Hz + NEUTRAL WIRE)

Machine colours: RAL 7035 light grey

Machine length: see drawing

Machine width: 1,700 mm

Machine height: 1,500 mm

Safety devices: CE

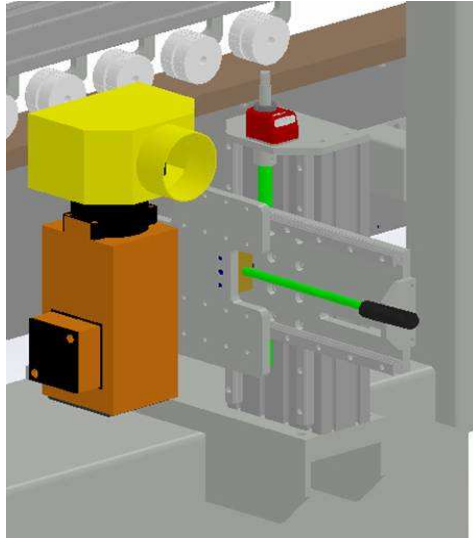
Compressed air feeding : 6 ÷ 8 Bar

Piece loading-Unloading: Manual

Extracted air consumption: 5,500 m³/h (at speed of 25 /sec)

Dust suction ports: Nr. 2 - Ø 120 mm & Nr. 5 - Ø 100 mm

MILLING UNIT MOD. "TP L-F" + SOUNDPROOF PROTECTION CABIN



Profile shaping unit type Toupie + (OPT.) PROTECTION CABIN.

(Motor spindle) Fixed shaping unit, to mould and groove the panel edge.

Horizontal and Vertical adjusting axes equipped with numerical position display for rapid machine conversion.

The units are located under noise suppression hoods to meet protection regulations and are equipped with a safety brake device.

Suction: The efficient suction system is equipped with openings fixed near the working zone of the units; dust and shavings are piped in the main conduct where an external exhaustor must be connected.

TECHNICAL DATA UNITS CTL130

Motor power: 3 kW (4 hp)

Motor shaft speed variable by inverter: 3.000 ÷ 6.000 rpm

Angular adjusting: 0° FIXED

Tools Dimensions: Ø 180 x 50 mm

Ø motor shaft: 40 x 100 mm and rings spacers

Diameter for dust extraction inlet: n.1 Ø 120 mm

Air suction capacity: 1,000 m³/h at 25 mt/sec

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SANDING BELT UNIT FOR STRAIGHT OR SHAPED EDGES MOD. "AT110"





Sanding unit for flat edges or profiles, with air cushion pad, counter shaped in respect to the profile to be sanded, with pressure that can be regulated.

Mechanical oscillation of the abrasive belt with amplitude from 0 to 20 mm (it depends on the belt abrasive type).

Forward and backward movement of the pad electronically controlled by electronic control.

Backward of the sanding pad in case of the belt breaking during the phase of working.

Blower for cleaning and cooling the sanding belt fitted on driving pulley with open and closed automatically controlled with electronic control.

Belt tension on the lateral pulley instead of driving pulley.

Double sensibility of the pad for the best copying sensibility with the profile to be worked; in case the pad is used like calibrating unit, the sensibility can be excluded.

The pad is complete with mechanical end of stroke.

Mechanical digital readouts on the axis of the unit.

It is inclinable from -15° to $+90^{\circ}$ by screw.

The pad of sanding is interchangeable by means of a quick device with locking screws; the pressure of working of the pad is pneumatically adjustable with end of stroke's control.

Suction: The efficient suction system is equipped with openings fixed near the working zone of the units; dust and shavings are piped in the main conduct where an external exhauster must be connected.

TECHNICAL DATA UNITS AT110

Motor power: 2.2 kW (3 hp) ATEX 3G servo-ventilated

Oscillation belt motor: 60 W

Rotation speed variable by inverter: $70 \div 1,700$ rpm // $0,5 \div 12,5$ m/sec

Angular adjusting: from -15° to $+90^{\circ}$

Pulleys height: 110 mm

Sanding belt size: 2,800 x 100h mm

Suction outlet diameter: n.2 \varnothing 100 mm

Air suction capacity: 1,400 m³/h @ 25 mt/sec

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N. 1 Scotch-brite wheels de-nibbing unit MOD. "SB"

Abrasive wheel sanding unit counter shaped to the profile to be sanded.

These units are of a motor-spindle type.

They can be positioned anywhere in the working area and can use sanding wheels, abrasive disk, brushes of various hardness and grain.

They are suitable for sanding / denibbing of rough and coated profiles. (Wheels for sanding chipboard & MDF profiles, Mixed flap (abrasive paper & cloth) for sanding & denibbing simple profiles without deep grooves & sharp edges, Tynex for texture effects & coarse denibbing of stain, flap wheel Scotch Brite for denibbing between coats of lacquers & primers, flexi sand (combination of bristle & abrasive papers) for sanding profiles in MDF or solid wood & for denibbing between coats of lacquer & primer.

Each disc sanding unit is tiltable mechanically with Rack and worn screw.
The motor spindle is complete with flanges and spacers.
All 3 adjusting axes equipped with numerical position display for rapid machine conversion.
Wheel sanding unit with automatic compensator controlled by electronic control.
Each disc sanding unit is fitted on a support with a third slide in working axis, and it's tiltable mechanically, with graduated scale.

Suction

The efficient suction system is equipped with openings fixed near the working zone of the units; dust and shavings are piped in the main conduct where an external exhaustor must be connected.

Technical features:

- *Motor power: Hp 3 (kW 2.2)
- *Rotation speed adjustable by inverter: from 420 up to 1,700 turns/min.
- *Wheel spindle Ø : 30 mm
- *Wheel spindle flange Ø : 76 mm
- Maximum wheel Ø: 200 mm
- *Maximum wheel height : 100 mm.
- Suction hood intakes: nr. 1 Ø 100 mm each unit